

Work Order ID 103634

103634

Page 1

June-24-13 1:59:45 PM

Item ID: D2892-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: SUPPORT

Start Date: 6/24/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/05/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-06-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2892 | B | | | | | | | | |

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA082
2-Debur

OFC 2013-08-11

12

φ

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

JFL 2013-08-11

12

φ

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

D.A 13/08/12

12

φ

DAS
08
2-08

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 103634

103634

Page 2

June-24-13 1:59:45 PM

Item ID: D2892-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: SUPPORT
 Start Date: 6/24/13 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 7/05/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------|
| 130 *130* HandFXtube | Memo | 0.00 | | | | 12 | Ø | Ø | AS 13-8-14 |
| Hand Finishing Crosstubes | Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time | | | | | | | | |
| 140 *140* QC | QC3- Inspect Part Finish | 0.00 | | | | 12 | | | DAS 05 8-83 13-08-15 |
| Quality Control | Memo | 0.00 | | | | | | | |
| 170 *170* Packaging | Identify as per dwg & Stock Location: 8-tubes Ass'y | 0.00 | | | | 12 | | | DAS 05 8-83 13-08-15 |
| Packaging | Memo | 0.00 | | | | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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Work Order ID 103634

103634

Page 3

June-24-13 1:59:45 PM

Item ID: D2892-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SUPPORT

Start Date: 6/24/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/05/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

13/8/2013
MCS 1308-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------------|----------------------------------|----------------------------------------|------------------------------------|----------------------------------------------|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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Picklist Print

June-24-13 1:59:44 PM

Page 1

Work Order ID: 103634

Parent Item: D2892-1

Parent Item Name: SUPPORT

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C02.11.26Added P/O KJ
 IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04 as per dwg
 rev.B DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| DSK077 | | Manufactured | No | | | 110 | Each | 7.0000 | 0.5 | 6 | | | |
| D2892-1 TURNING DETAIL | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT060

7

101398

7

104461

6 JFC 2013-08-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|----------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width:33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width:33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width:33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
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| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
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| Training | | | | | | | | | |
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FAULT CATEGORY

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|------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 103634 |
| Description: Ø2.500 Support | | Part Number: D2892-1 |
| Inspection Dwg: D2892 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| HAAS Section | | | | | | | | |
| AA | 0.115 | 0.150 | | 0.131 | 0.132 | 0.133 | 0.132 | 0.133 |
| AB | 0.290 | 0.310 | | 0.300 | 0.300 | 0.300 | 0.300 | 0.300 |
| AC | 0.040 | 0.060 | | 0.049 | 0.048 | 0.048 | 0.048 | 0.049 |
| AD | 0.115 | 0.150 | | 0.126 | 0.126 | 0.126 | 0.125 | 0.126 |
| AE | 0.240 | 0.260 | | 0.249 | 0.249 | 0.249 | 0.249 | 0.251 |
| AF | 0.188 | 0.193 | | 0.191 | 0.191 | 0.191 | 0.191 | 0.191 |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | 0.250 |
| AH | 1.116 | 1.156 | | 1.142 | 1.141 | 1.141 | 1.140 | 1.143 |
| AI | 0.454 | 0.474 | | 0.463 | 0.463 | 0.462 | 0.462 | 0.462 |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | 0.250 |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | 0.063 |
| AL | 0.257 | 0.262 | | 0.262 | 0.262 | 0.262 | 0.262 | 0.262 |
| AM | 1.663 | 1.683 | | 1.676 | 1.676 | 1.676 | 1.676 | 1.677 |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | 0.063 |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | 0.032 |
| AP | 2.779 | 2.789 | | 2.782 | 2.784 | 2.784 | 2.784 | 2.784 |
| AQ | | | | | | | | |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | |
|------------------------------|-------------------------|
| Measured by: JFC | Date: 2013-08-11 |
| Audited by: H.A. | Date: 13/08/12 |
| Preliminary Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |
| B | 08.04.21 | Reformat | KJ/JLM | |
| C | 12.01.31 | Dwg Rev updated | KJ | |
| D | 13.05.22 | Dimensions updated | KJ | |

| | | | |
|-----------------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 103634 |
| Description: Ø2.500 Support | | Part Number: | D2892-1 |
| Inspection Dwg: D2892 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 16 | 17 | 18 | 19 | 10 |
| HAAS Section | | | | | | | | |
| AA | 0.115 | 0.150 | | 0.133 | 0.133 | 0.134 | 0.132 | 0.132 |
| AB | 0.290 | 0.310 | | 0.300 | 0.300 | 0.300 | 0.300 | 0.300 |
| AC | 0.040 | 0.060 | | 0.050 | 0.047 | 0.048 | 0.048 | 0.047 |
| AD | 0.115 | 0.150 | | 0.125 | 0.125 | 0.125 | 0.125 | 0.125 |
| AE | 0.240 | 0.260 | | 0.249 | 0.248 | 0.247 | 0.248 | 0.247 |
| AF | 0.188 | 0.193 | | 0.191 | 0.191 | 0.191 | 0.191 | 0.191 |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | 0.250 |
| AH | 1.116 | 1.156 | | 1.140 | 1.141 | 1.140 | 1.140 | 1.138 |
| AI | 0.454 | 0.474 | | 0.463 | 0.462 | 0.462 | 0.462 | 0.462 |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | 0.250 |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | 0.063 |
| AL | 0.257 | 0.262 | | 0.262 | 0.262 | 0.262 | 0.262 | 0.262 |
| AM | 1.663 | 1.683 | | 1.671 | 1.675 | 1.675 | 1.675 | 1.674 |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | 0.063 |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | 0.032 |
| AP | 2.779 | 2.789 | | 2.782 | 2.784 | 2.784 | 2.784 | 2.784 |
| AQ | | | | | | | | |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

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|-----------------------|------------------|
| Measured by: Jfe | Date: 2013-08-11 |
| Audited by: H.A | Date: 13/08/12 |
| Preliminary Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |
| B | 08.04.21 | Reformat | KJ/JLM | |
| C | 12.01.31 | Dwg Rev updated | KJ | |
| D | 13.05.22 | Dimensions updated | KJ | |

| | | |
|------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 103634 |
| Description: Ø2.500 Support | | Part Number: D2892-1 |
| Inspection Dwg: D2892 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|---|---|---|
| Dim | Min | Max | Go/No Go Gauge | 1 1 | 1 2 | 3 | 4 | 5 |
| HAAS Section | | | | | | | | |
| AA | 0.115 | 0.150 | | 0.132 | 0.132 | | | |
| AB | 0.290 | 0.310 | | 0.300 | 0.300 | | | |
| AC | 0.040 | 0.060 | | 0.048 | 0.049 | | | |
| AD | 0.115 | 0.150 | | 0.125 | 0.126 | | | |
| AE | 0.240 | 0.260 | | 0.248 | 0.249 | | | |
| AF | 0.188 | 0.193 | | 0.191 | 0.191 | | | |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | | | |
| AH | 1.116 | 1.156 | | 1.135 | 1.140 | | | |
| AI | 0.454 | 0.474 | | 0.461 | 0.462 | | | |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | | | |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | | | |
| AL | 0.257 | 0.262 | | 0.262 | 0.262 | | | |
| AM | 1.663 | 1.683 | | 1.675 | 1.676 | | | |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | | | |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | | | |
| AP | 2.779 | 2.789 | | 2.783 | 2.783 | | | |
| AQ | | | | | | | | |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | |
|------------------------------|-------------------------|
| Measured by: JFC | Date: 2013-08-11 |
| Audited by: B.A. | Date: 13/08/12 |
| Preliminary Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |
| B | 08.04.21 | Reformat | KJ/JLM | |
| C | 12.01.31 | Dwg Rev updated | KJ | |
| D | 13.05.22 | Dimensions updated | KJ | |

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF: DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF. XXXX = ± 0.010) UNLESS OTHERWISE NOTED

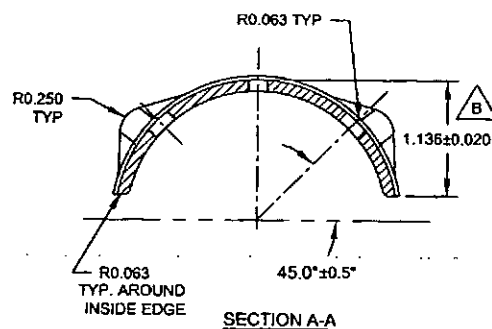
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

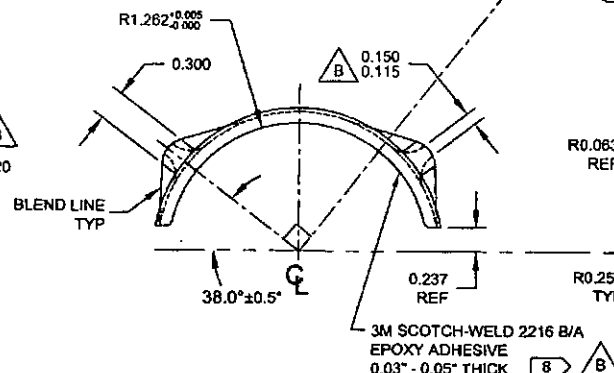
6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.41 lb

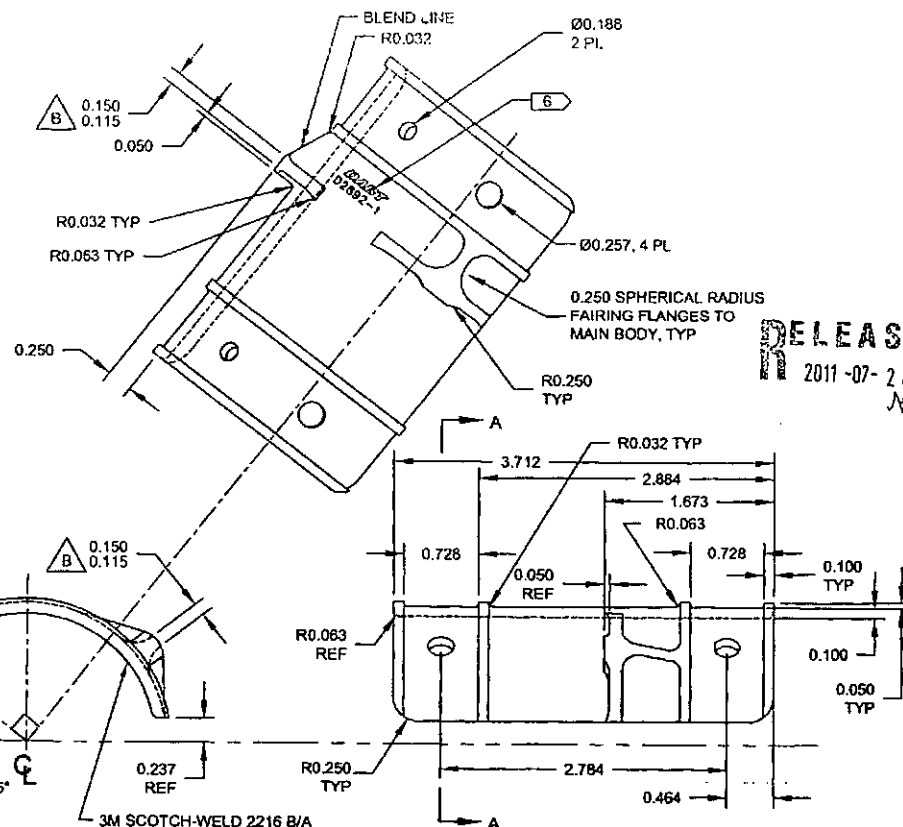
8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



SECTION A-A



D2892-1 SUPPORT



RELEASED
2011-07-28

| | | | |
|------------|----------------------------------------------------------------------------------------|----|----------|
| B | REV. FINISH, ADD 3M 2216, ADD H925 MATL. OPTION, UPDATE TOLERANCE (ZIN DS-1.85-1.86-1) | CP | 11.07.15 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | Q | | |
| DRAWN | Q | | |
| CHECKED | ASS | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.07.15 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2892
TITLE: Ø2.500 SUPPORT
REV. B
SHEET 1 OF 1
SCALE: NTS

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